

Work Order ID 64815

Friday, December 17, 2010 8:00:37 AM



Page 1

Item ID: D3204-041

Accept



Setup Start



Revision ID:

Item Name: Release Pedal Assembly

Stop



Start Date: 12/16/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 1/21/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-27-17

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3204

Rev A1

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- Weld assembly as per Dwg D3204 using Jig D3204-041 T1. □2- Drill #40 diameter hole in the center of Ø0.760" c'bore on D3204-5 arm prior to weld. □3- Use JB weld compound to plug the hole after assembly. □4- Grind JB weld flush after it is cured. □Ident

EL 11-3-10 *(24)*

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

4 *0* *BE 11/03/14*

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Duloz 1/4

(74)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

4 0 11/03/14

140

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

M 115128.

Cover holes for bushing☐ START TIME
3:15 ☐ OVEN TEMPERATURE: 320° ☐ FINISH
TIME: 3:45.

4 11-3-15

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4 0 11/03/16

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Item ID: D3204-041 Accept  Setup Start 
Revision ID:
Item Name: Release Pedal Assembly Stop 
Start Date: 12/16/2010 Start Qty: 4.00  Cust Item ID:
Required Date: 1/21/2011 Req'd Qty: 4.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Install D3204-7 bushing as shown in Dwg D3204								

EP 11/03/16 (4)

170		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

ml 11/03/16 (4)

180		0.00							
	Identify as per dwg & Stock Location <i>GA</i>								
Packaging	Memo	0.00							
Packaging									

SB 11/03/16

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Revision ID:

Stop



Item Name: Release Pedal Assembly

Start Date: 12/16/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 1/21/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/16

mr

11-03-16

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NOTE: Date & initial all entries

Picklist Print

Friday, December 17, 2010 8:00:42 AM

Page 1

Work Order ID: 64815

Parent Item: D3204-041

Parent Item Name: Release Pedal Assembly

Start Date: 12/16/2010


Required Date: 1/21/2011

Start Qty: 4.00

Required Qty: 4.00


Comments: IPP: ☐ C ☐ 05.08.11 ☐ Added Step 25 ☐ KJ/JLM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3204-1  Tube		Manufactured	No			100	Each	6.0000	1	4			
--	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--


Location Loc Qty Loc Code

WA	5	
60883	5	
WA20	1	
57547	1	

D3204-11  Plate		Manufactured	No			100	Each	40.0000	1	4			
--	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location Loc Qty Loc Code

ST45	14	
57522	14	
WA	26	
55463	26	

D3204-3  Arm		Manufactured	No			100	Each	5.0000	1	4			
---	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location Loc Qty Loc Code

WA	5	
57737	5	

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 2

Work Order ID: 64815

Parent Item: D3204-041

Parent Item Name: Release Pedal Assembly

Start Date: 12/16/2010

Required Date: 1/21/2011

Start Qty: 4.00

Required Qty: 4.00

D3204-5
Arm
Manufactured No

100 Each

4.0000

1

4



EL 11-3-10

Location

Loc Qty

Loc Code

WA

4

57738

4

4

D3204-7
Bushing
Manufactured No

100 Each

21.0000

2

8



EL 11-3-10

Location

Loc Qty

Loc Code

ST041

16

60871

16

3

ST045

5

48631

5

5

D3204-9
Pedal
Manufactured No

100 Each

7.0000

1

4



EL 11-3-10

Location

Loc Qty

Loc Code

WA

1

43765

1

1

WA020

6

60884

6

3

D3204-13
Gusset
Manufactured No

160 Each

21.0000

2

8



EL 11-3-10

Location

Loc Qty

Loc Code

WA

21

58211

21

8

Friday, December 17, 2010 8:00:42 AM

Shop Packet Print

Page 2

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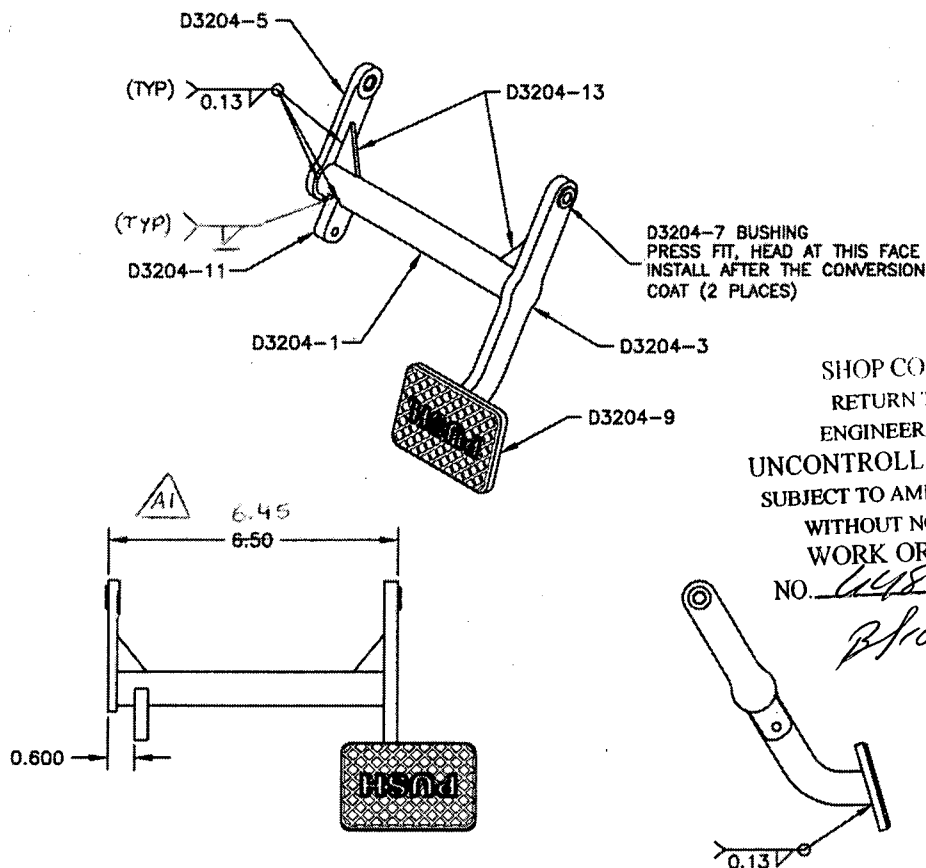
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY		SCALE NTS
A	04.01.27	NEW ISSUE	
A1	05.07.15	6.45 WAS 6.50	

RELEASED
04.04.30



D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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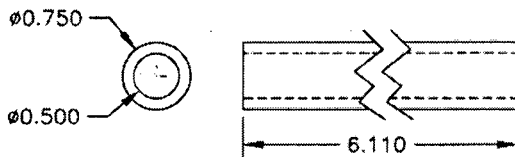
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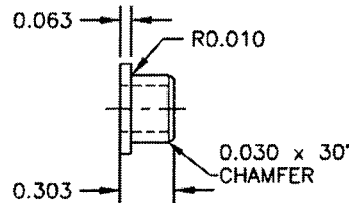


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3204	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

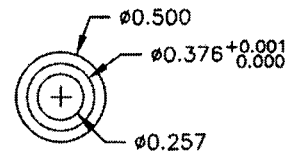
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04.04.05 *[Signature]*



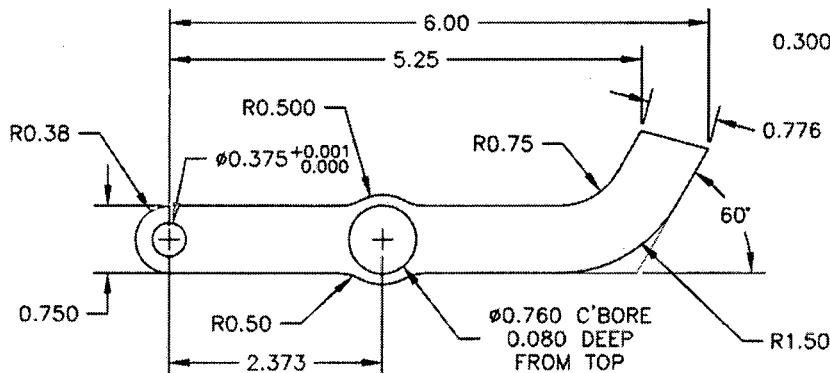
2 D3204-1 TUBE
SCALE 1:2



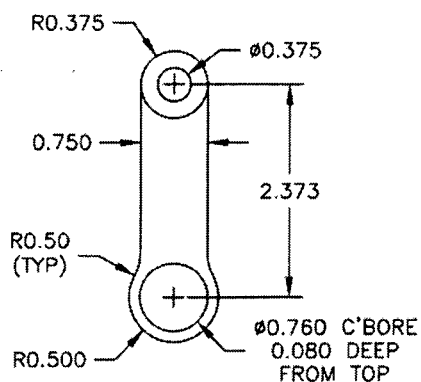
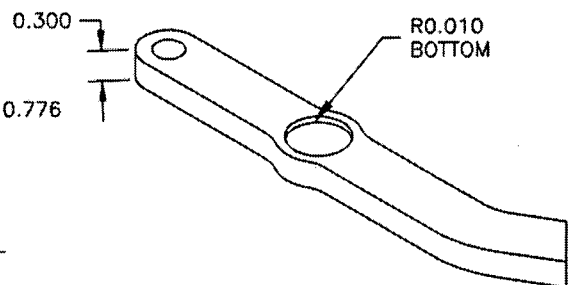
4 D3204-7 BUSHING
SCALE 1:1



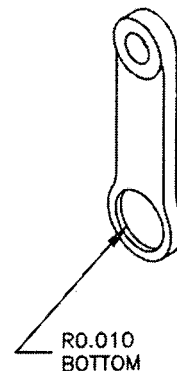
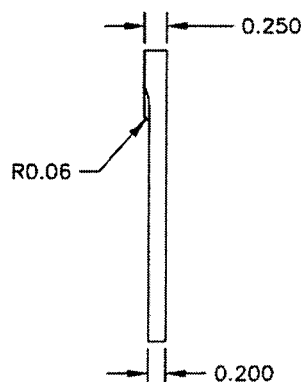
also 6/18/15



3 D3204-3 ARM
SCALE 1:2



3 D3204-5 ARM
SCALE 1:2



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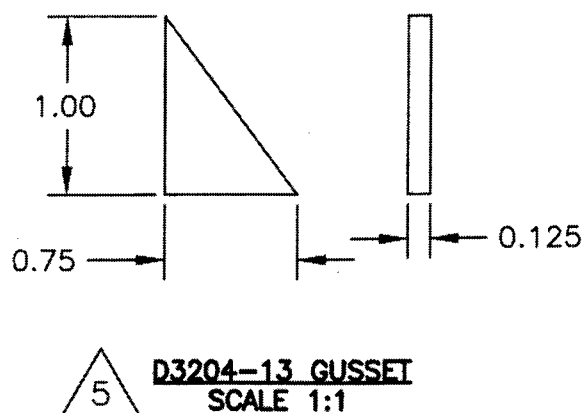
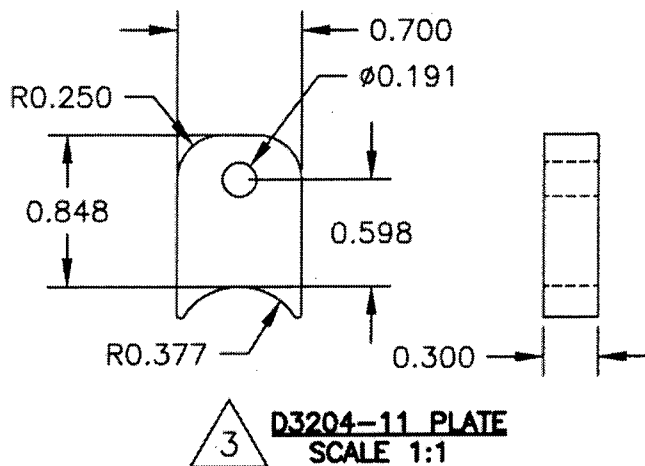
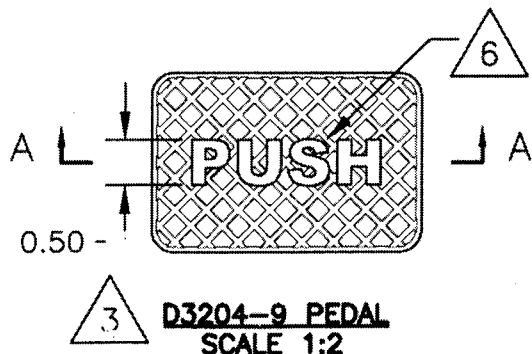
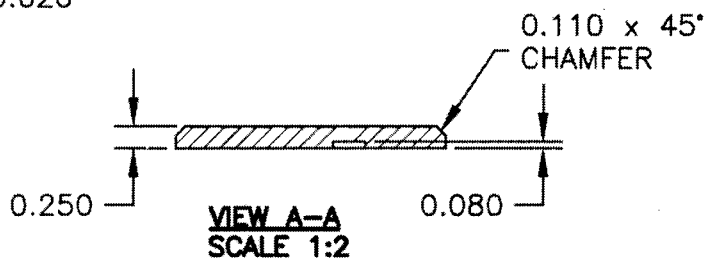
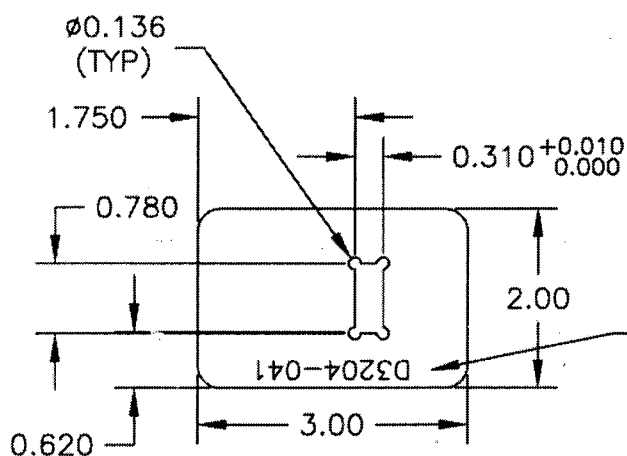
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3204	REV. A SHEET 3 OF 3
DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY		SCALE NTS

RELEASED
04.04.30



1044815

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